

Ship 27/03

Dart Aerospace Ltd.











Date: Tuesday, 3/18/2008 3:55:15 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 38087	
Estimate Number : 12812	
P.O. Number :	Part Number : D3610041
This Issue : 3/18/2008 S.O. No. :	Drawing Number : D3610 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 36085	Material :
Written By :	Due Date : 3/28/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JH 08 03 18</u>	
Comment : est rev A new issue 07.03.28 EC	
est rev B released, changed mat'l EC	

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	M4140NB1500X15000	AlSI 4140 Steel Bar
		
Comment: Qty.: 0.5775 f(s)/Unit Total : 5.7750 f(s) AlSI 4140 Steel Bar		
2.0	BAND SAW	BAND SAW
		
Comment: BAND SAW Cut blank 6.600 " long <u>M106468X5 pcs</u> <u>M106674X5 pcs</u>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA692 Rev: <u>AA</u> & Dwg D3610 Rev: <u>A</u> 2-Deburr per dwg D3610		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK		

J.L 08/03/24

J.L 08/03/24

SA 08/03/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/18/2008 3:55:15 PM
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Drawing Name: BRACKET

Job Number: 38087

Part Number: D3610041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-C'SINK AS PER DWG D3610

mf

08-03-25 (10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/25 (X10)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 106 442

m-1

08/03/26

(10X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-26

(X10)

11

10.0

MS21075L3

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nutplate

Batch: M 107 275

SB

08/03/26

(10)

11.0

MS20426AD34

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

RIVET

batch: M 102 401

SB

08/03/26

10

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Rivet Nut Plate as per Dwg D3610

ml 08/03/26

X10

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/26 (X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/18/2008 3:55:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 38087

Part Number: D3610041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 244A

8/3/06 SQ



15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D08/03/27

Job Completion



u 08/03/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

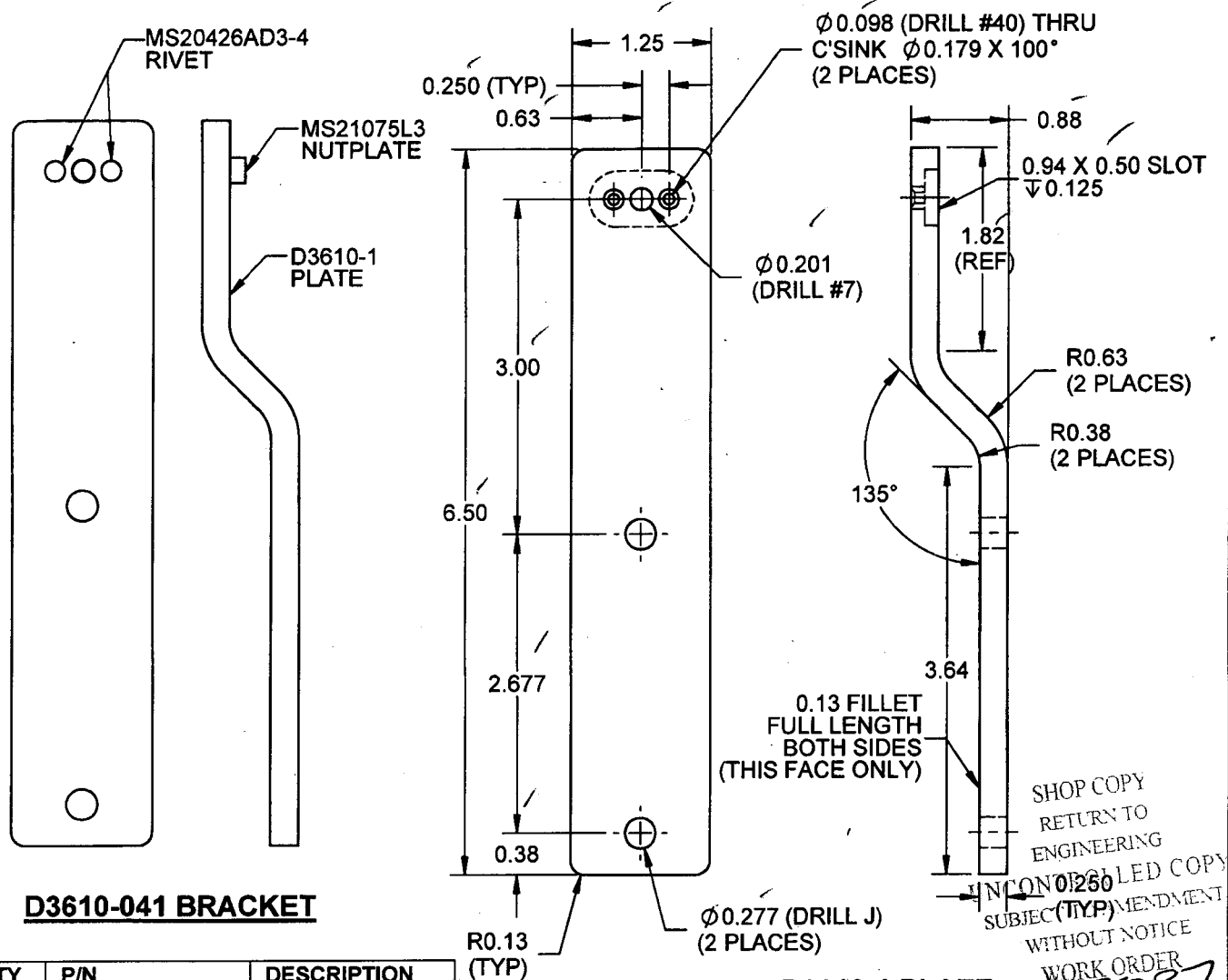
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>LE</i>	DRAWING NO. D3610	REV. A SHEET 1 OF 1
DATE 07.04.20		TITLE BRACKET	SCALE 2:3
REV A	DATE 07.04.20	DESCRIPTION NEW ISSUE	



QTY	P/N	DESCRIPTION
X	BRACKET	D3610-041
1	D3610-1	PLATE
1	MS21075L3	NUTPLATE
2	MS20426AD3-4	RIVET

D3610-041 NOTES:

1) IDENTIFY WITH DART P/N "D3610-041" USING FINE POINT PERMANENT INK MARKER

D3610-1 NOTES:

- 1) MATERIAL: 4130N STEEL BAR PER MIL-S-6758 OR AMS 6348 OR 6370 OR 6528 (REF DART SPEC M4130N-B) OR 4140N STEEL BAR PER MIL-S-5626 OR AMS 6382 OR 6349 OR 6529 (REF DART SPEC M4140N-B)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD		Work Order: 38087
Description: bracket		Part Number: D3610-041
Inspection Dwg: D3610 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+ .030	1.250	✓			
.250	+ .010	.250	✓			
.63	+ .030	.626	✓			
6.50	+ .030	6.499	✓			
3.00	+ .030	2.999	✓			
2.677	+ .010	2.677	✓			
.38	+ .030	.380	✓			
Ø 277	+ .005 - .001	.278	✓			
Ø 201	+ .005 - .001	.203	✓			
.098	+ .005 - .001	.098	✓			
.88	+ .030	.879	✓			
.94 X .50	+ .030	.936 X .500	✓			
↓ .125	+ .010	.115	✓			
6.380	+ .030	.375	✓			
.250	+ .010	.254	✓			

Measured by: J.L	Audited by: SA	Prototype Approval:
Date: 08/03/23	Date: 08/03/24	Date:
Rev	Date	Change
A		New Issue
		Revised by KJ/RF
		Approved